

**DEPARTMENT OF TRANSPORTATION****DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/Ala Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-025833**Date Inspected:** 19-Jul-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 1900**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 700**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China

<b>CWI Name:</b>	N/A			<b>CWI Present:</b>	<b>Yes</b>	<b>No</b>	
<b>Inspected CWI report:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Rod Oven in Use:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Electrode to specification:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Weld Procedures Followed:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Qualified Welders:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Verified Joint Fit-up:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
<b>Approved Drawings:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>	<b>Approved WPS:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>
				<b>Delayed / Cancelled:</b>	<b>Yes</b>	<b>No</b>	<b>N/A</b>

**Bridge No:** 34-0006**Component:** OBG Components**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance Inspector (QA Inspector) George Goulet was present during the times noted above for observations relative to the work being performed.

**OBG Trial Assembly Area**

Caltrans and ABF have agreed to conduct visual inspection (VT) and magnetic particle inspection (MT) of welds as part of a special joint inspection program. In response to ZPMC NDT Inspection Notification Sheets (NWIT) #09783 for MT in OBG Segment 13W:

This QA Inspector arrived at Segment 13W to perform random VT and then MT of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. Upon being unable to locate any ZPMC MT personnel performing this task, this QA Inspector called ZPMC QA Zhang Wei (ZQA). ZQA arrived at Segment 13W and informed this QA Inspector that no ZPMC MT crew was available for this QA Inspector to verify MT of finished welds.

This QA Inspector also randomly observed the following work in progress in the OBG Trial Assembly Area:

A ZPMC crew of approximately 4 workers was performing initial and final bolt tightening of OBG Segment 13E, FL3 area, bottom plate. Workers were tightening bolt sets with an air impact gun from the outside on the bolt end where no washer was present. This QA Inspector informed the workers that there must be a washer on the end of the bolt set from which the tightening occurs. The workers then moved the air impact gun to the nut end of the bolt sets which had the washer adjacent to the nut. The areas near where the faying surfaces come together

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showed copious amounts of debris, including welding and torch cutting slag, sandblast grit, grinding debris, drilling shavings, and what appeared to be sand. This QA Inspector was unable to determine if any of the above noted types of debris were lodged between the faying surfaces.

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

As noted above.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang, 150-0042-2372, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Goulet, George	Quality Assurance Inspector
<b>Reviewed By:</b>	Riley, Ken	QA Reviewer

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